

SPLIT - 1

Work Order ID 71899 - 1

Wednesday, July 13, 2011 11:16:03 AM

Page 1

Item ID: D4292-1

Accept

Revision ID:

Item Name: Fitting

Start Date: 7/14/2011

Start Qty: 4.00

Required Date: 7/28/2011

Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *MUF*

Date: 11-07-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4292

C

100

0.00



BAND SAW

Bandsaw

Jeaspa Bandsaw

Memo

Cut Blank to 6.250"

Batch: 118201

****GRAIN DIRECTION MUST BE ALONG 4.00"*****

0.00

on 11/08/29

6

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Machine per folio FB002

DWG REV: *C*

FOLIO REV: *C*

2- deburr rough edges

0.00

SA 11/18/30

5

1

11/10/29

W/O: 71899-1

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		(-1)					

Part No: D4292-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: # Date: 11.09.02
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 11/09/02

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.08.31	110	RE MATIL IS CHIPPED ON INNER BOLT HOLES.	CP 11.08.31	RE-BORE TO CLEAN UP MATIL. GET ENG APPROVAL. -OTHERWISE - SCRAP.	Now on split -2			
11/08/31	110	1 part scrap. run load wrong program in the machine. part too small R.L. operator error LOA.	U 11.08.31 per DS 042	scrap and destroy replace Qty 1 Batch 118201	and 11/08/31	U 11.08.31	DS 042	6 11/08/31

NOTE: Date & initial all entries

Work Order ID 71899

Wednesday, July 13, 2011 11:16:03 AM



Page 2

Item ID: D4292-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

SL

11/8/25

5

φ

121



Mill Conv

Conventional Milling Machine

Memo

DRILL & TAP FOR HELICOIL AS PER DWG

0.00

0.00

11/08/31

6

φ

122



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

11/08/31

6

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71899

Wednesday, July 13, 2011 11:16:03 AM



Page 3

Item ID: D4292-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

L.A 11/08/31

5

0

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

5x Ø M-11/08/31

145



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

MASK THREADED HOLE

0.00

Start Time: 2:00

Temp: 320 °F

Finish Time: 2:30

5x Ø M-11/08/31

MV 7745

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71899

Wednesday, July 13, 2011 11:16:03 AM



Page 4

Item ID: D4292-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

5 d M11/08/31

151



Small Fab

Small Fab

Memo

INSTAL HELICOIL

0.00

0.00

5 d M11/08/31 (5)

152



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11 08 31 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71899

Wednesday, July 13, 2011 11:16:03 AM



Page 5

Item ID: D4292-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Packaging

Packaging

Identify as per dwg & Stock Location: ST

0.00

Memo

0.00

WF

11-08-31

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/8/31

WF

11-08-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 13, 2011 11:16:00 AM

Page 1

Work Order ID: 71899

Parent Item: D4292-1

Parent Item Name: Fitting



Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-14 JLM VERIFIED BY:DD IPP REV
B: AS PER REV B 11-02-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B4.000x4.00 0		Purchased	No			100	f	26.8665	0.52	2.189474			



7075-T73 Bar 4.0 x 4.0



Location	Loc Qty	Loc Code
MAT	12.1255	
→ 118201	12.1255	
MAT005	14.741	
116153	0.75	
116324	7.95	
116764	6	
116867	0.041	

3.12 am 11/08/21

MS21209F1-10

Purchased

No



HELI COIL

Each 84.0000

4



SS 11/08/21 (S)

Location	Loc Qty	Loc Code
ST305	84	
116977	84	

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

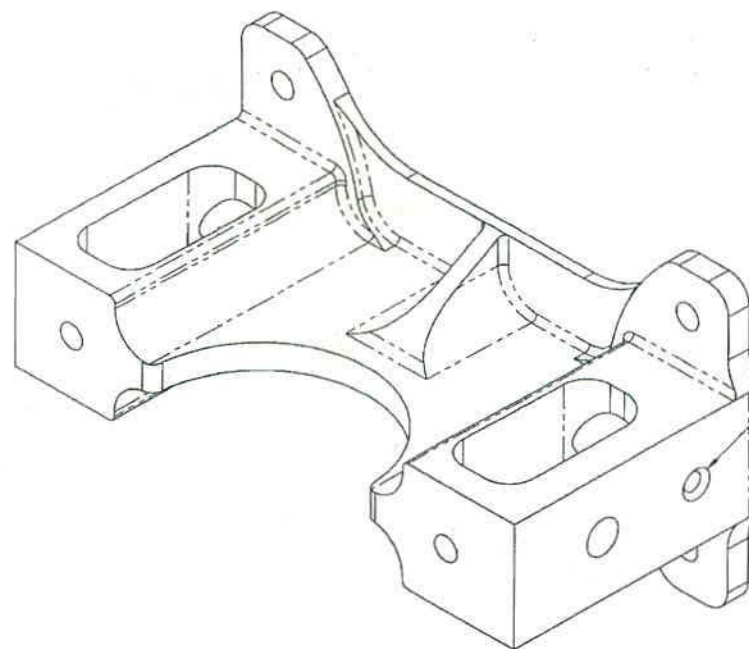
DART AEROSPACE LTD		Work Order: 71899
Description: Fitting		Part Number: D4292-1
Inspection Dwg: D4292	Rev: C	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.063	+/-0.010	.063	✓		R-G	
0.250	+0.030/-0.010	.256	✓		Vern Jk-3	
0.125	+0.030/-0.010	.130	✓		"	
2.95	+/-0.030	2.950	✓		"	
0.275	+/-0.010	.277	✓		"	
0.800	+/-0.010	.799	✓		"	
0.825	+/-0.010	.824	✓		"	
0.375	+/-0.010	.375	✓		"	
0.31	+/-0.030	.311	✓		"	
0.88	+/-0.030	.880	✓		"	
0.663	+/-0.010	.664	✓		RA26	Vern
Ø0.381	+0.000/-0.001	Ø.381	✓		"	
1.125	+/-0.010	1.126	✓		"	
1.063	+/-0.010	1.064	✓		"	
3.44	+/-0.030	3.439	✓		"	
2.450	+/-0.010	2.450	✓		"	
1.325	+/-0.010	1.325	✓		"	
0.300	+/-0.010	.304	✓		"	
1.200	+/-0.010	1.200	✓		"	
2.84	+/-0.030	2.833	✓		H-G	
0.19	+/-0.030	.191	✓		Vern Jk-3	
5.86	+/-0.030	5.860	✓		"	
5.99	+/-0.030	5.990	✓		"	
Ø0.272	+0.006/-0.001	.273	✓		"	
Ø0.266	+0.006/-0.001	.268	✓		"	
1.75	+/-0.030	1.752	✓		"	
R0.25	+/-0.030	.25	✓		R-G	
R0.06	+/-0.030	.060	✓		R-G	
4.875	+/-0.010	4.875	✓		Vern Jk-3	
0.493	+/-0.010	.494	✓		"	
C-bore Ø0.765	+/-0.010	.764	✓		"	
0.250	+0.030/-0.010	.248	✓		Mic Jk-4	
0.680	+/-0.010	.680	✓		Vern Jk-3	
2.250	+/-0.010	2.250	✓		H-G	
4.500	+/-0.010	4.500	✓		"	
R1.275	+/-0.010	1.275	✓		"	
R0.031	+/-0.010	.032	✓			



11/08/31
He



MS21209F1-10 HELICAL COIL 1X
REF

GRAIN
DIRECTION

D4292-1 FITTING

RELEASE
2011-02-01

NOTES:

- 1) MATERIAL: 7075-T73/T7351/T73510/T73511 BAR
PER AMS-QQ-A-200/1 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4292-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.02 lbs

C	1.064 WAS 1.235 (C1-2), Ø0.296 WAS Ø0.323 (B3-2), ADD HELICAL COIL (D1-2)	CP	10.12.23
B	0.800 WAS 0.78 (C8-2), 0.825 WAS 0.81 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN	 <div style="text-align: center;"> DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA </div>		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	DRAWING NO. D4292 TITLE FITTING (206L/407 FWD)		
DATE	10.12.23	REV. 1 OF 1 SCALE NT	
<small> COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT, AND THE INFORMATION CONTAINED HEREIN, IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PURPOSES AND ON THE EQUIPMENT SPECIFICALLY IDENTIFIED HEREIN. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. </small>			

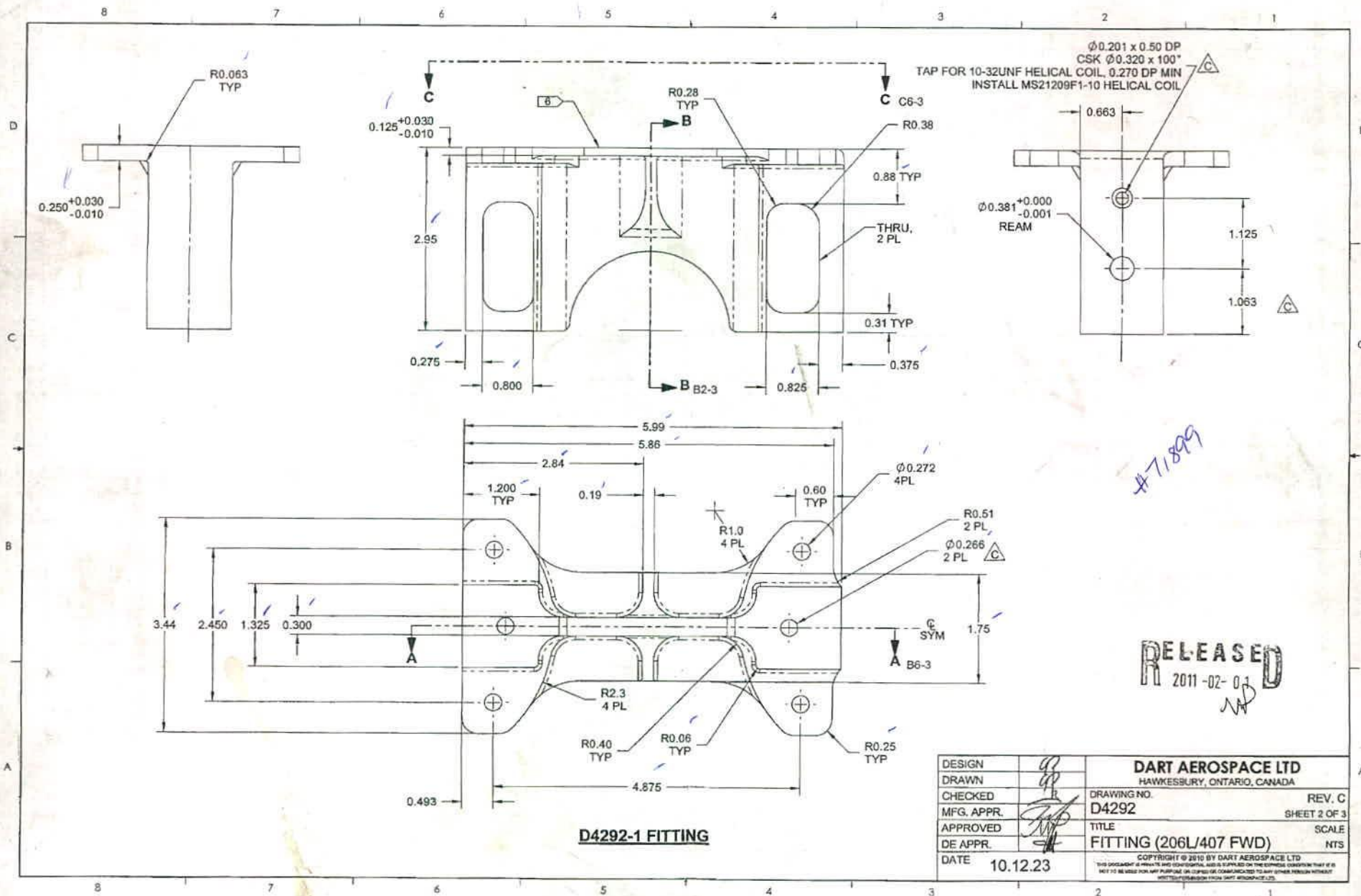
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4292-1 FITTING

RELEASED
2011-02-01
NW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4292	REV. C
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		FITTING (206L/407 FWD)	SCALE
DE APPR.			NTS
DATE	10.12.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

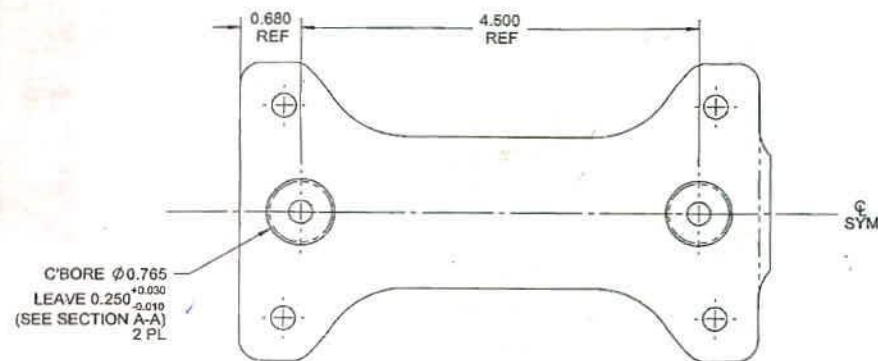
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

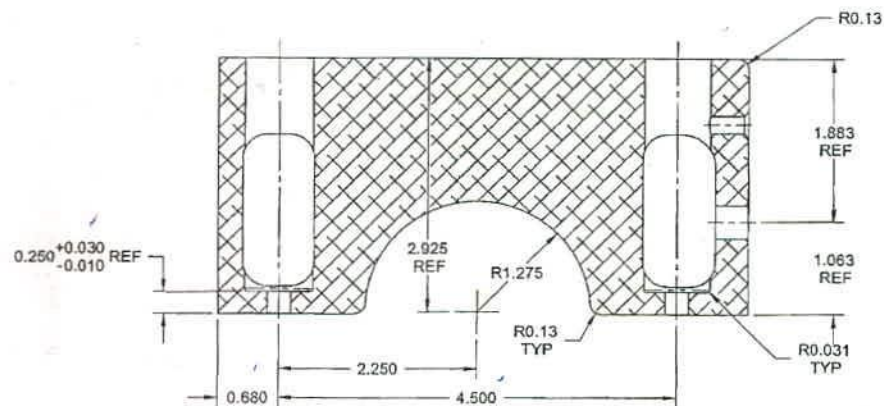
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

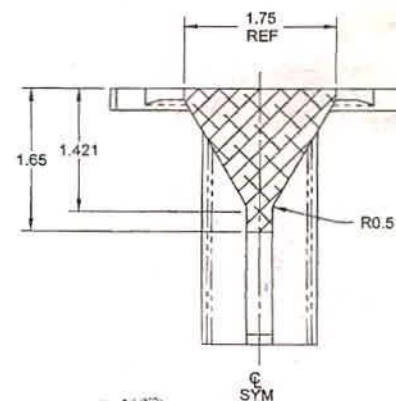
8 7 6 5 4 3 2 1



VIEW C-C D3-2



SECTION A-A A3-2



SECTION B-B C4-2

RELEASED
 2011-02-01

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4292	REV. C
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		FITTING (206L/407 FWD)	SCALE
DE APPR.			NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries